

**Work Order ID 109472**

November-21-13 2:28:38 PM

**\*109472\***

Page 1

Item ID: D3012-5

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Decal

Stop

**\*NS2\***

Start Date: 11/21/13 Start Qty: 6.00

**\*8\*** 12

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00

**\*8\***

Customer:

Reference:

Approvals:	Process Plan: <u>ML5</u>	Date: <u>13-11-22</u>	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop		<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3012	Rev A

100	0.00
-----	------

<b>*100*</b>	PURCHASING
--------------	------------

Purchasing	Memo
------------	------

Purchasing	Issue P/O: <u>22/89</u>
------------	-------------------------

Make as per Dwg D3012
-----------------------

Manufacture from 3M 7mil masking film p/n 8522CP
--

Material release note is required
-----------------------------------

CD 13/11/26 (6) 12

110	Receive & Inspect for Damage & Mat'l Certs	0.00
-----	--	------

<b>*110*</b>	
--------------	--

Packaging	Memo
-----------	------

Packaging	Ensure Material Release Note is attached
-----------	--

P 13/11/09 (12)

120	QC6- Inspect dimensions to drawing	0.00	DAS 27 9-89
-----	------------------------------------	------	-------------------

<b>*120*</b>	
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QC	Memo
----	------

Quality Control	
-----------------	--

13/12/04

12

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date:

## WORK ORDER NON-CONFORMANCE / UPDATE



## Work Order update only

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Suspected/Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function								
			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence								
			<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge								
			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled								
			<input type="checkbox"/> Other								

**Work Order ID 109472****\*109472\***

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November-21-13 2:28:38 PM

Item ID: D3012-5

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Decal

Stop

**\*NS2\***

Start Date: 11/21/13 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 11/21/13 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*130\***

Packaging

Packaging

Memo

*Stock  
23*

0.00

*13/12/14 02*

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Quality Control

Memo

0.00

*13/12/14**13-12-14*

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

### DISPOSITION

Rework  
 Scrap  
 Use-as-is  
 Suspected Unapproved

### AGAINST DEPARTMENT/PROCESS

Skid-tube  
 Machining  
 Thermoforming  
 Large Fab

Crosstube  
 Small Fab  
 Finishing  
 Composite

Water Jet  
 Prod. Eng. Coor.  
 Rec/Store/Packaging  
 Supplier

Engineering  
 Quality  
 Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	Bending	General	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric		BOM/Route	Grain	Over/Under tolerance	Set-up
	Cracks		Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave		Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs		Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing		Countersink	Misaligned/off center	Positioned Wrong	
	Heat Treat		Cut Too Short	Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube		Drawing	Misread		
	Marks/Chatter		Drill Holes	Off-set		
	Turning Sequence		Finish	Out of Calibration		
	Wave/Twist in Tube		Fit/Function	Out of Sequence		

# Picklist Print

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Work Order ID: 109472

Parent Item: D3012-5

Parent Item Name: Decal

Start Date: 11/21/13

Required Date: 11/21/13

Start Qty: 6.00

Required Qty: 6.00

Comments: Rev A 01.04.06New IssueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3012-5P Decal		Purchased	No			110	Each	0.0000	1	612	13/2/4	12	

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order:

### DISPOSITION

### AGAINST DEPARTMENT/PROCESS

Part No.

Rework Skid-tube Crosstube Water Jet Engineering 

NCR No.

Scrap Machining Small Fab Prod. Eng. Coor. Quality Use-as-is Thermoforming Finishing Rec/Store/Packaging Other Suspected Unapproved Large Fab Composite Supplier 

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General	Outside Dimensions	Pressure/Forced
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Set-up <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Weld <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>	
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>	
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A SHEET 1 OF 1
DATE		TITLE	SCALE
01.03.30		DECAL	1:1
A	01.03.30	NEW ISSUE	

RELEASED  
01.04.01

- POINT A -  
SWL=300lb/136kg  
DO NOT USE WITH POINT B  
P/N D3012-1

D3012-1

- POINT B -  
SWL=500lb/227kg  
DO NOT USE WITH POINT A OR C  
P/N D3012-3

D3012-3

- POINT C -  
SWL=300lb/136kg  
DO NOT USE WITH POINT B  
P/N D3012-5

D3012-5

MATERIAL: WHITE LETTERS ON BLACK ADHESIVE BACK  
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP

22-11-25  
109472 M25

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Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO22189**

Purchase Order Date 11/26/2013

PO Print Date 11/27/2013

Page Number 1 of 2

**Order From :** VC-STU001  
STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

**Ship To :** DART AEROSPACE LTD  
1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

*REvised*

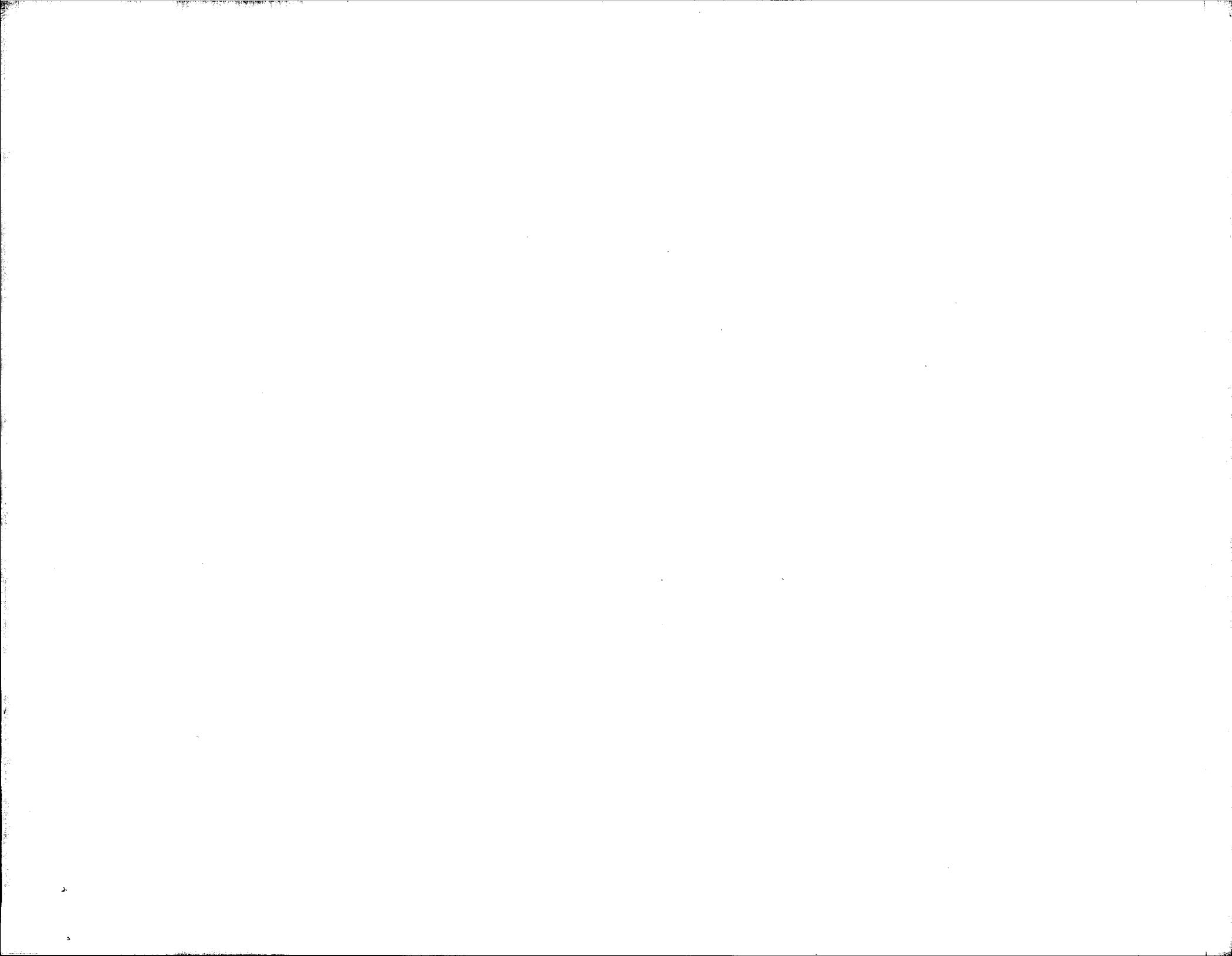
**Contact Name**  
**Vendor Phone** 613 632 5449  
**Ship To Contact**  
**Ship To Phone**  
**Ship Via:** Yours ppd  
**Ship Acct:**

**Buyer** Chantal Lavoie  
**Customer POID**  
**Customer Tax #** 10127-2607  
**Terms** Net 30  
**Currency** CAD  
**FOB** Destination-Collect

*013/11/27*

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3012-3P	Decal	12/2/2013 Yes	12/2/2013	12.00 Each	\$6.67	\$80.00
	AS PER DWG D3012 REV. A B109471					<b>Line Total:</b>	<b>\$80.00</b>
2	D3012-5P	Decal	12/2/2013 Yes	12/2/2013	12.00 Each	\$6.67	\$80.00
	AS PER DWG D3012 REV. A B109472					<b>Line Total:</b>	<b>\$80.00</b>
3	D4085-3P	Placard, Instructions	12/2/2013 Yes	12/2/2013	6.00 Each	\$13.33	\$80.00
	AS PERD WG D4085 REV. C B109629					<b>Line Total:</b>	<b>\$80.00</b>

**Note:**



**Studio de Lettrage**

210 Main Street W  
Hawkesbury, Ontario K6A 2H6

**INVOICE**

Invoice No.: 21330  
Date: 12/04/2013  
Ship Date:  
Page: 1  
Re: Order No. WO11454

**Sold to:**

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario K6A 1K7

**Ship to:**

Dart Aerospace Ltd  
Hawkesbury, Ontario

**Business No.:** 82500 7651 RT0001

Item No.	Unit	Quantity	Description	Tax	Unit Price	Amount
		12	D3012-3P stickers	H	2.9167	35.00
		1	set up	H	50.0000	50.00
		12	D3012-5P stickers	H	2.9167	35.00
		1	set up	H	50.0000	50.00
			H - HST 13% HST			22.10
Studio de Lettrage HST: #825007651RT0001						
Shipped By:	Tracking Number:					
<b>Comment:</b>						
Sold By:					<b>Total Amount</b>	192.10

\*\*\*\*Certificate of Conformity\*\*\*\*

Customer:

*Studio Lettrage*

<u>Purchase Order #:</u>	<u>Packing Slip #:</u>	<u>Part #:</u>	<u>Serial #:</u>
	711459		

Description:

Quantity:

*24 stickers.*

Certification:

We hereby certify that:

1. The above the listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

*Avery*

<u>APPROVAL:</u>	<u>DATE:</u>
<i>Alder Flury</i>	

Signature:

*Alder Flury*

*DEC 4<sup>th</sup> 2013*

Title: Project Coordinator

## PRODUCT DATA SHEET



### Avery® IPM™ 2031

issued: 01/04/2005

#### Introduction

Avery® IPM™ 2031 is a high quality pressure-sensitive vinyl film, designed for use on wide format inkjet printers. Avery® IPM™ 2031 has excellent printing properties, allowing crisp print quality with bright and vibrant colours. Avery® IPM™ 2031 offers rapid ink drying and a water-resistant material. It combines good adhesion during its life and easy removal afterwards.

#### Description

Facefilm: 80-micron premium white calendered, topcoated vinyl.

Adhesive: removable, acrylic based

Backing paper: one side coated kraft paper, 140 g/m<sup>2</sup>

#### Features

- Excellent printability
- Vibrant and bright colours
- Crisp print quality
- Spray water resistant with specific pigmented inks
- Good adhesion, excellent removability
- Warranty on outdoor durability

#### Recommendations for use

A wide variety of full-colour graphics for indoor - and **short/medium term outdoor** applications such as posters, murals, displays, exhibition stands, vehicle graphics etc. Avery® IPM™ 2031 is suitable for application to a wide variety of substrates and will remove cleanly for up to 1 year after application.

IPM media should be handled with care as any surface contamination may affect the print quality. Media should be processed in an environment of 15-25°C and 30-70% relative humidity. After drying, the finished prints should be wrapped in polyethylene film and despatched flat or rolled with the printed side facing outwards. To protect prints against water, UV/light and abrasion, overlamination with a clear film is recommended. For specific details of Avery® DOL combinations, refer to "Technical Bulletin 5.3. Recommended combinations of Avery® Overlaminate and Avery® Digital Print Media".

**Always test your combination of Avery® IPM™ medium, inkjet printer and inks prior to commercial use.**

#### Compatibility

Avery® IPM™ 2031 is compatible with a broad selection of inkjet printers, when printing with pigmented, water based inks. For specific details refer to "Technical Bulletin 5.6 Avery Dennison Inkjet Print Media - Printer compatibility".

#### Durability:

Avery® IPM™ 2031 is warranted for outdoor use in conjunction with pigmented outdoor inks from HP, Encad and Colorsprint. The warranted period varies from type of application and type of overlaminate from 18 months up to 5 years. For full details, see our Avery® IPM™ Outdoor warranty.



[www.averygraphics.com](http://wwwaverygraphics.com)

Graphics Division  
Rindijk 86, P.O. Box 118  
2694 ZG Hazerswoude - The Netherlands  
Tel +31 71 3421500 - Fax +31 71 3421538



## PRODUCT CHARACTERISTICS

Avery® IPM™ 2031

### Physical properties

Features	Test method <sup>1</sup>	Results
Caliper, facefilm	ISO 534	80 µm
Gloss	ISO 2813, 20°	1%
Dimensional stability	DIN 30646	0.3 mm. max
Adhesion, initial	FINAT FTM-1, stainless steel	180 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	260 N/m
Flammability		Self extinguishing
Accelerating ageing	DIN 53587, 500h exposure	No negative impact on film
Shelf life	Stored at 22° C/50-55 % RH	Performance
Removability		2 years
Not when applied to: Nitro-cellulose paints, ABS, Polystyrene, certain types of PVC		
Durability <sup>2</sup>	Overlaminated with DOL 4300 Overlaminated with DOL 1000, DOL 1100 with overlaps Overlaminated without overlaps for static applications only Without overlaminate and used for static, Non-abrasive application ONLY	5 years 3 years 2 years 18 months

Only when printed with ENCAD GO, HP and Colorsprint pigmented inks and when properly applied in accordance with our application instructions. Only applicable for vertical exposure.

### Temperature range

Features	Results
Application temperature	Minimum: +10°C
Service temperature	-20°C to +80°C

### Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change. In case of any ambiguities or differences between the English and foreign versions of these Conditions, the English version shall be controlling.

### Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

#### 1) Test methods

More information about our test methods can be found on our website.

#### 2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



[wwwaverygraphics.com](http://wwwaverygraphics.com)

### Graphics Division

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